

Work Order ID 53834-2

November 20, 2009 8:58:45 AM

Page 1

Item ID: D4011-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Clamp, Short

Start Date: 11/19/09 Start Qty: 80.00

Cust Item ID:

Required Date: 11/26/09 Req'd Qty: 80.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4011

B

101

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

cut per Drwg D4011

Rev. BB Prog. Rev. B

Deburr if necessary

B 9-11-21

115

102

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-11-21

103

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

809/11/23

counts
N14

φ

Work Order ID 53834

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Page 2

Item ID: D4011-5

Accept



Setup Start



Revision ID:

Item Name: Clamp, Short

Stop



Start Date: 11/19/09 Start Qty: 80.00



Cust Item ID:

Required Date: 11/26/09 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

104

0.00



Small Fab

Memo

0.00

SO 09/11/25

94
11/3

0

Small Fab

Form as per dwg
D4011 Rev.B

105

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

SO 09/11/25

counter

1.96

φ

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/26/26 (54)

Work Order ID 53834

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Page 3

Item ID: D4011-5

Accept



Setup Start



Revision ID:

Item Name: Clamp, Short

Stop



Start Date: 11/19/09 Start Qty: 80.00



Cust Item ID:

Required Date: 11/26/09 Req'd Qty: 80.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/26
R/ 09/11/26
96

Picklist Print

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Page 1

Work Order ID: 53834



Parent Item: D4011-5

Parent Item Name: Clamp, Short

Start Date: 11/19/09

Required Date: 11/26/09

Comments: IPP RevA:(new issue) revC as per dwg 09.11.18 DD verified by:JLM

Start Qty: 80.00

Required Qty: 80.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No				sf	25.9521	4.8000	7.		



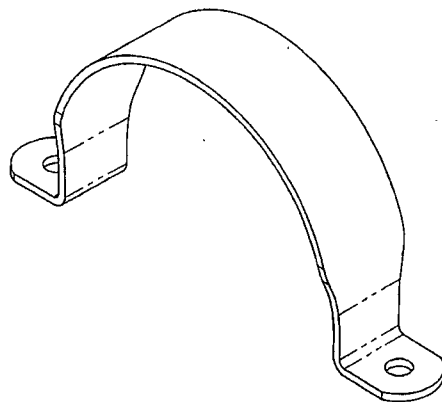
304SS sheet .080

189-1121

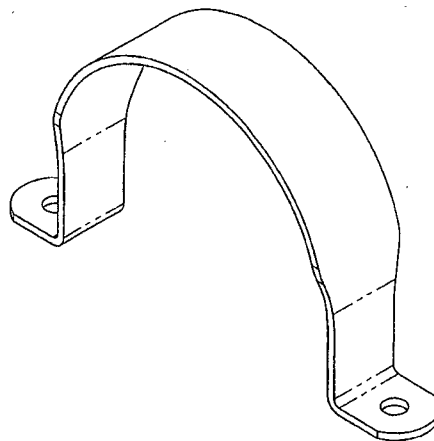
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	25.9521	
110993Q	25.9521	

118

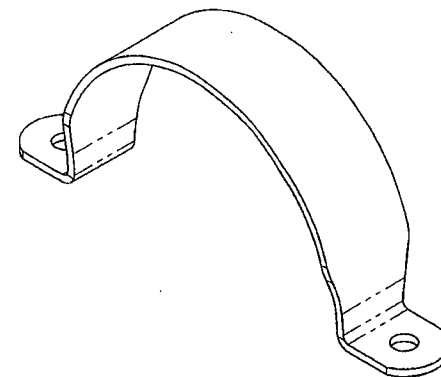
110993



D4011-1 CLAMP, SHORT



D4011-3 CLAMP, LONG



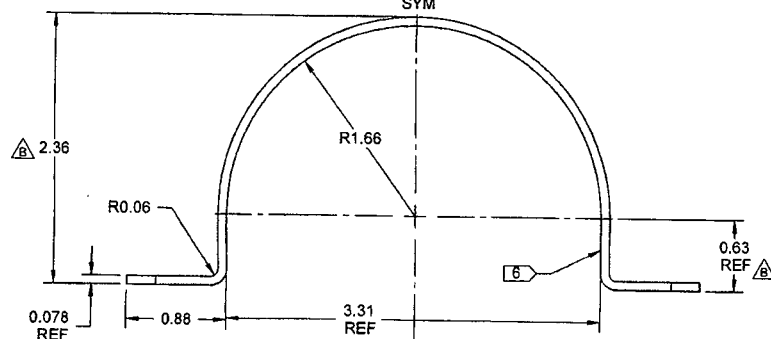
D4011-5 CLAMP, SHORT (OEM)

538 34

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 6524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

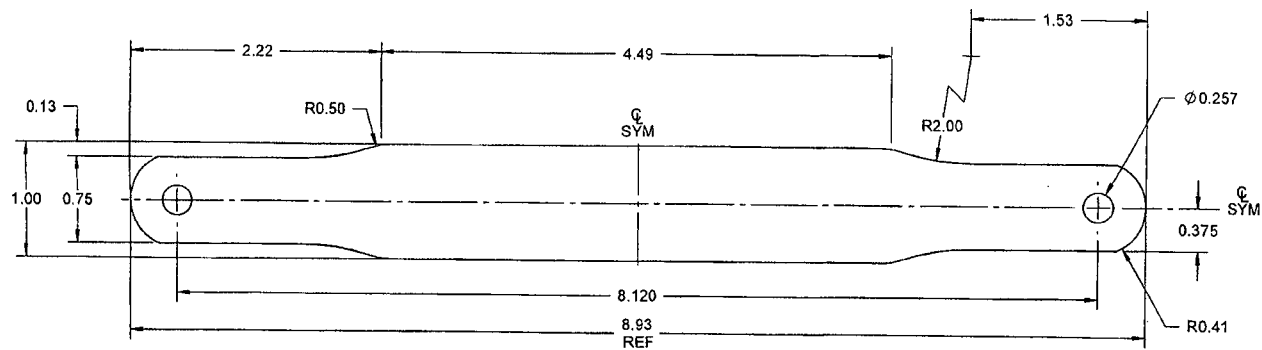
B	SHORTEN HEIGHT OF -1A-3 CLAMPS BY 0.125; ADDED -5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES	MB	09.11.11
A	NEW ISSUE	MB	09.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4011	SHEET 1 OF 4
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DE APPR.		CLAMP	NTS
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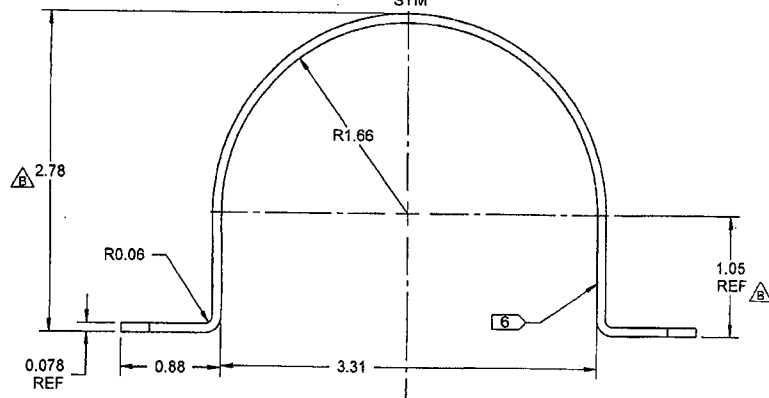
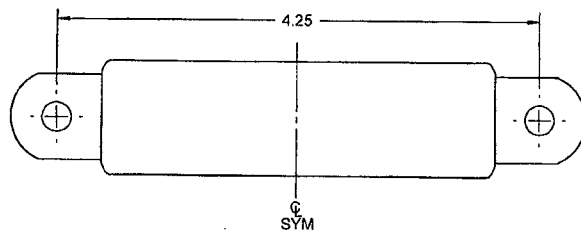
D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)

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DRAWN	<i>1</i>		SHEET 2 OF 4
CHECKED	<i>A.S.</i>		SCALE
MFG. APPR.	<i>1</i>		NTS
APPROVED	<i>1</i>		
DE APPR.	<i>1</i>		
DATE	09.11.11		

8 7 6 5 4 3 2 1



D4011-3F CLAMP FLAT PATTERN, LONG

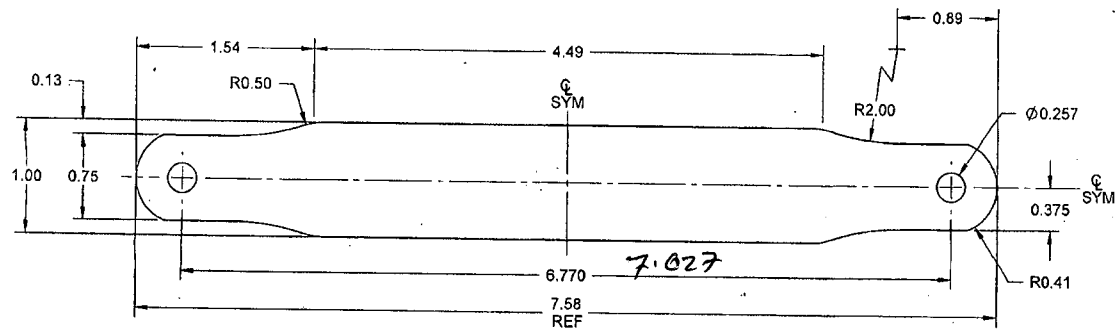


D4011-3 CLAMP, LONG
(MAKE FROM D4011-3F)

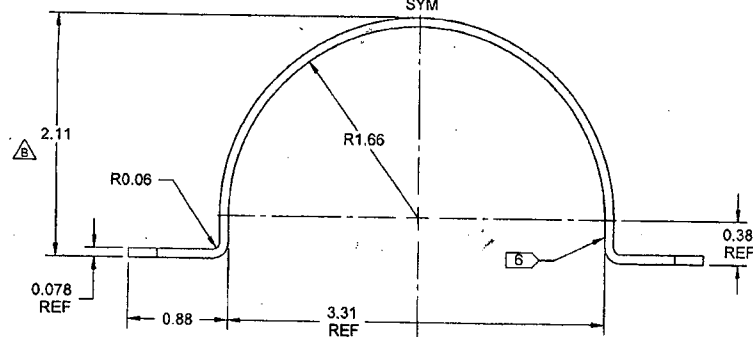
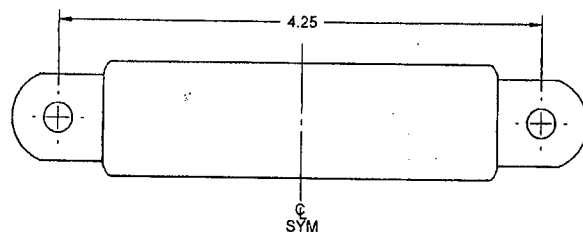
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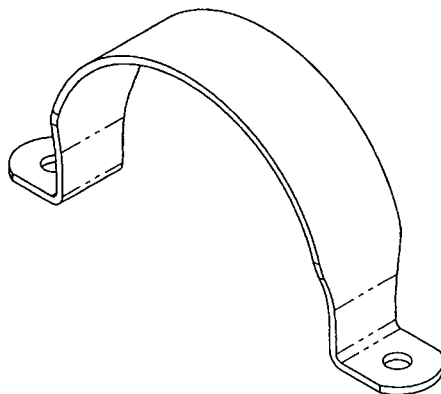
D4011-5F CLAMP, SHORT (OEM) FLAT PATTERN



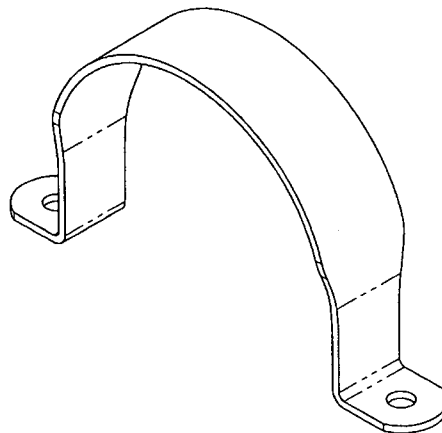
D4011-5 CLAMP, SHORT (OEM)
(MAKE FROM D4011-5F)

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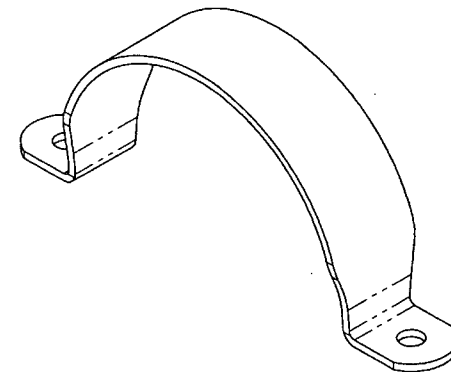
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D4011-1 CLAMP, SHORT



D4011-3 CLAMP, LONG



D4011-5 CLAMP, SHORT (OEM)

53834

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2009-11-24
MP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

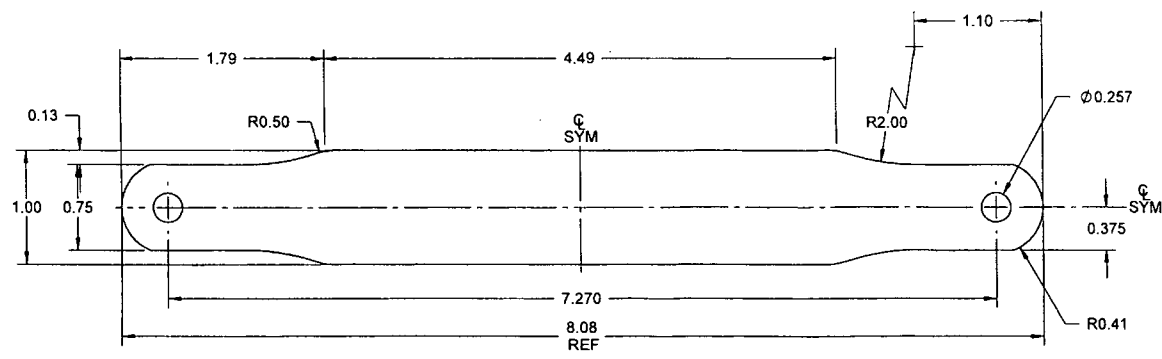
B	SHORTEN HEIGHT OF -1/3 CLAMPS BY 0.125; ADDED -.5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES	MB	09.11.11
A	NEW ISSUE	MB	09.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

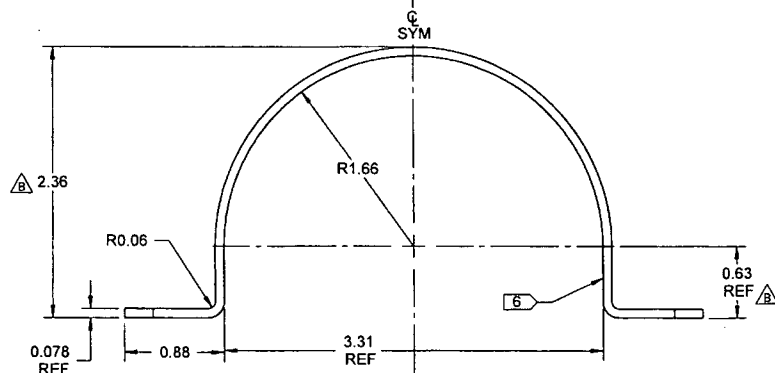
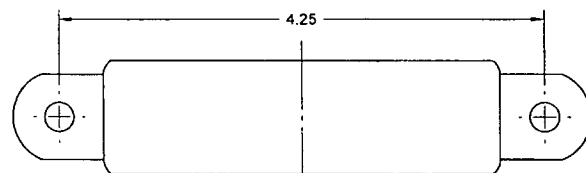
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SHEET 1 OF 4
TITLE **CLAMP** SCALE
NTS

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8 7 6 5 4 3 2 1



D4011-1F CLAMP, SHORT FLAT PATTERN



**D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)**

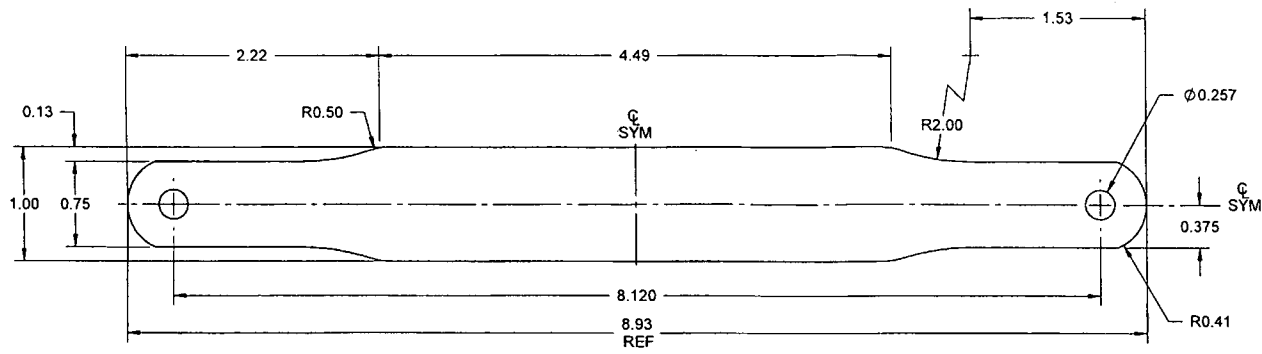
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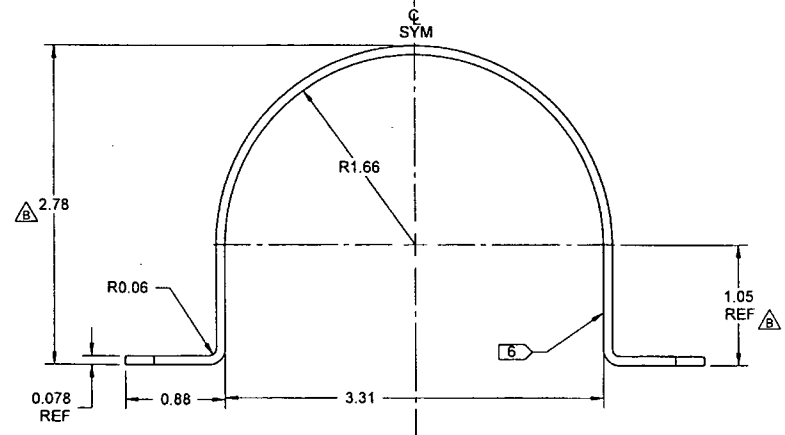
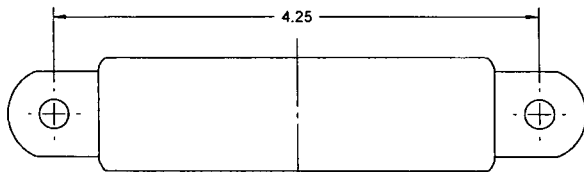
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D4011-3F CLAMP FLAT PATTERN, LONG



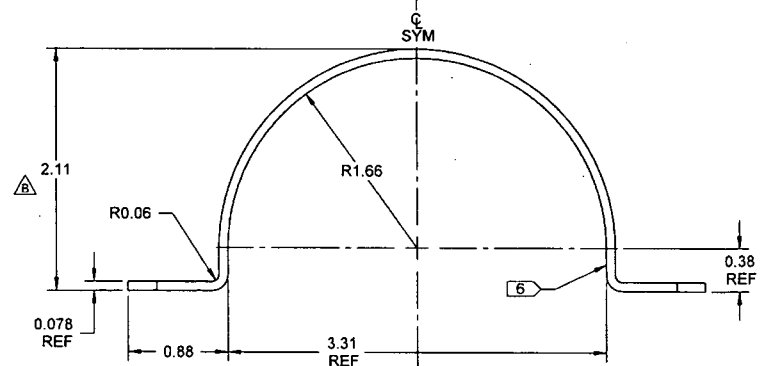
D4011-3 CLAMP, LONG
(MAKE FROM D4011-3F)

S3834

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DESIGN	<i>B</i>	DART AEROSPACE LTD	
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D4011-5 CLAMP, SHORT (OEM)
(MAKE FROM D4011-5F)

53834

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